

N.E. — On page 6, before paragraph [0052], insert the following new paragraph:
--DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS--.

IN THE CLAIMS

Please amend the claims, without prejudice, as follows:

A 3. (Amended) A process in accordance with Claim 1, characterized in that the additive material (8) is introduced in a plurality of locations of the distribution arrangement.

4. (Amended) A process in accordance with Claim 1, characterized in that the additive material (8) is metered to the injection material by dosages.

5. (Amended) A process in accordance with Claim 1, characterized in that the introduction of the additive (8) is blocked during a post-pressure phase of the injection molding process.

6. (Amended) A process in accordance with Claim 1, characterized in that the additive (8) is introduced to the injection material at approximately the same temperature as that of the injection material.

A2 8. (Amended) An injection molding machine for the manufacture of injection molded articles, in particular of toothbrush bodies, ^{comprising} with an injection molding die (1) and an injection unit (2) ^{having a plurality of} mold cavities (5), a distributor channel arrangement (4) with distributor or conveyance channels (150) that carry injection material between the injection unit (2) and ^{said} individual mold cavities (5) and at least one mixing apparatus (450) for the injection material, and at least one connection for an additive line, wherein the mixing apparatus and the additive line are integrated into the distributor channel

arrangement (4, 4a, 100), and

A² 10 that the mixing apparatus is part of the distributor or conveyance channels (150)
of the distributor arrangement (4) and that the additive ~~feed(s)~~ ^{line is} for the additive (8) ~~is (are)~~
11 connected to the ^a channel main distributor (6) or the ^a channel subdistributor (14)
12 connected to the injection unit (2) and/or in a nozzle connected to the mold cavity.

10 10. (Amended) An injection molding machine in accordance with Claim 8,
characterized in that the feed (10) for the additive material (8) can be closed.

11 11. (Amended) An injection molding machine in accordance with Claim 8,
characterized in that the ^{with} shutoff valve (15) is designed as a dosage valve for the additive
material (8).

12 12. (Amended) An injection molding machine in accordance with Claim 8,
characterized in that in a case of a plurality of line connections for additives (8), at least
one is connected directly to a mold cavity (5).

A³ 13. (Amended) An injection molding machine in accordance with Claim 8,
characterized in that the mixing apparatus includes at least one mixing chamber (17)
formed by a cross-sectional change, preferably by a cross-sectional expansion.

14. (Amended) An injection molding machine in accordance with Claim 8,
characterized in that a hot channel distributor (100) is provided for handling of melts
(101), which, before injection into the mold cavities have been mixed with at least one
additive material, and the hot channel distributor (100) includes a melt channel (150)
arrangement, in which at least one feed line section (151) is provided for delivery of the
additive material (102), an additive material line, with a terminating outlet into the feed

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line section (151), at least one mixer (300) aligned in a direction of flow, and in that the mixer (300) is formed as a mixing section which includes at least two sections (301, 302), the axes of which are not aligned to coincide with one another.

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17. (Amended) An injection molding machine in accordance with Claim 15, characterized in that by the use of a plurality of mixers (300) the length and the cross-section of the single mixing sections are made equal for the attainment of balanced flow ratios.

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18. (Amended) An injection molding machine in accordance with Claim 14, characterized in that the exit opening (303) of the first section (301) is connected to the entry opening (304) of the second section (302) of the two sections (301, 302), by a flow direction reversal fitting (305) of the melt channel (150), wherein the direction of flow in the first section (301) is essentially opposite to the direction of flow in the second section (302).

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22. An injection molding machine in accordance with Claim 18, characterized in that the first and the second sections (301, 302) are respectively provided as static mixers (450).

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24. (Amended) An injection molding machine in accordance with Claim 22, characterized in that the two static mixers elements (450) comprise a plurality of screw shaped, twisting deflection plates (451, 452), which are arranged alternately right and left behind one another, wherein each deflection plate (451) possesses two edges (453) standing at right angles to the material flow direction, which are connected with the respective adjacent edge (454) of the neighboring deflection plate (452), and are turned through a specified angle in relation to said edge (454).

A7 26. An injection molding machine in accordance with Claim 24, characterized in that the adjacent edges (453, 454) of neighboring deflection plates (451, 452) are connected together by spot welding.

34. (Amended) An injection molding machine in accordance with Claim 32, characterized in that the needle valve (203) travel is limited to 0.1 to 0.01 mm.

35. (Amended) An injection molding machine in accordance with Claim 8, characterized in that within the distribution channel, a separating distance to the entry point of an additive feed (10) from a mold cavity, is determined in consideration of a volume of the article to be produced by injection molding and by an anticipated volume of additive required for the article.

36. (Amended) An injection molding machine in accordance with Claim 8, characterized in that a temperature adjustment apparatus is provided for the additive (8), preferably by means of a heating installation placed at the additive material feed (10).

A8 37. (Amended) An injection molding machine in accordance with Claim 8, characterized in that one or more distributor channel branches include one or more additive material feeds (10).

38. (Amended) An injection molding machine in accordance with Claim 8, characterized in that a plurality of additive feeds (10) are provided in a channel leading to the mold cavities (5) in the direction of flow, and in that the additive feeds (10) can be optionally closed.